

Date: Wednesday, 11/03/2009 12:59:28 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB
Job Number : 46454	
Estimate Number : 13597	
P.O. Number :	Part Number : D38153
This Issue : 11/03/2009 S.O. No. :	Drawing Number : D3815 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 45835	Material :
Written By :	Due Date : 31/03/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUL 09.03.11</u>	
Comment : Est Rev:A 08-09-18 new issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M2024T3S063

2024-T3 .063 sheet



Comment: Qty.: 0.5177 sf(s)/Unit Total: 3.1059 sf(s)
 2024-T3 .063 sheet
 batch: 110980

ml 09.03.29

(6)

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3815
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

ml 09.03.29

(6)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 09.03.29

(6)

4.0

QC8

SECOND CHECK

**Comment:** SECOND CHECK

S 09/03/30

(46)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

FL 09/03/30

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:59:29 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 46454

Part Number: D38153

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-30

ⓧ

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

ST137

AS 09/03/31 ⓧ

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/01 ⓧ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-03-31

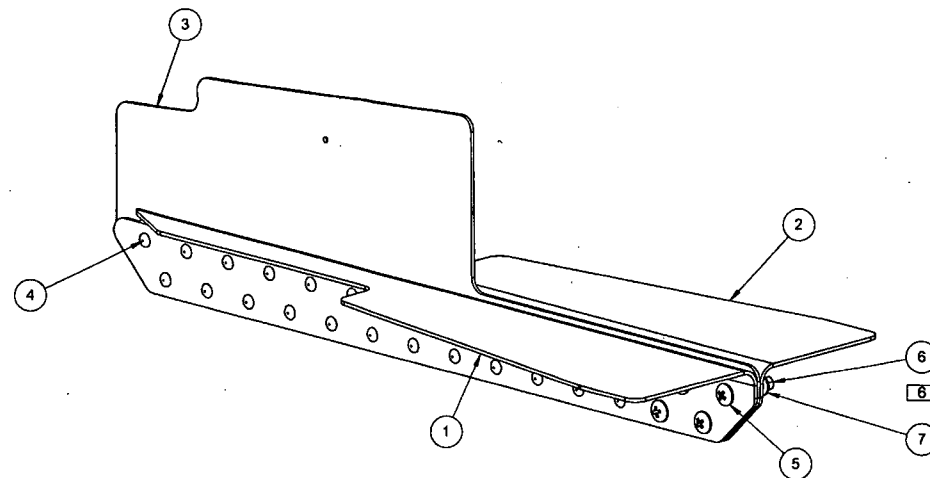
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	25
5	AN526C832R14	SCREW	4
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

D3815-041 WEB ASSEMBLY

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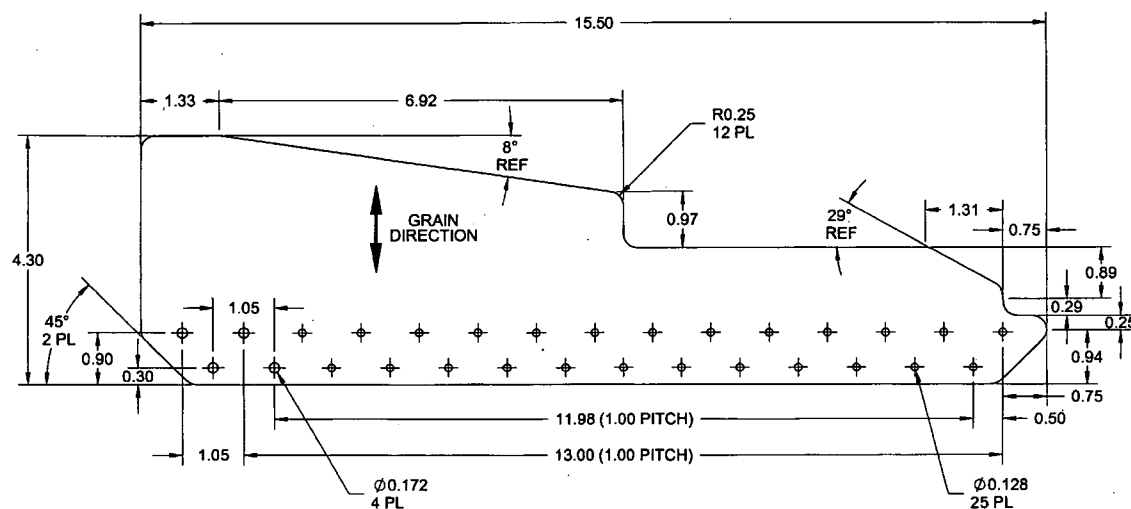
- NOTES:**
- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
 - 5) WEIGHT: 0.88 lbs
 - 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

RELEASED
 09/03/10

A	NEW ISSUE	BY	08.09.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.22		

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. A
D3815	SHEET 1 OF 5
TITLE	SCALE
WEB	NTS

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D3815-1F FLAT PATTERN

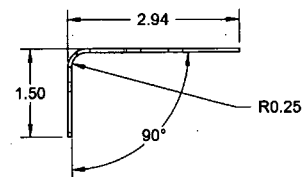
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NOTES:

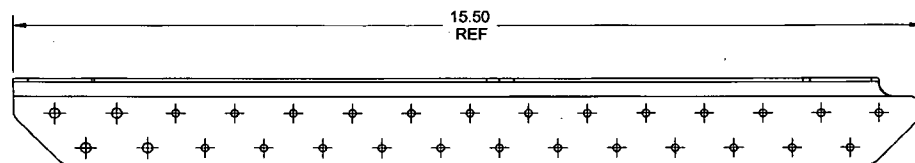
- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

RELEASED
09/01/13

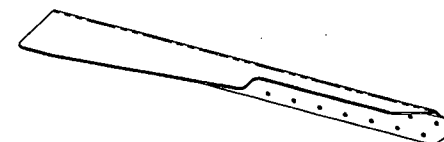
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3815	SHEET 2 of 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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A diagram of a tapered bar with a central hole. A dashed line indicates a cross-section of the bar.




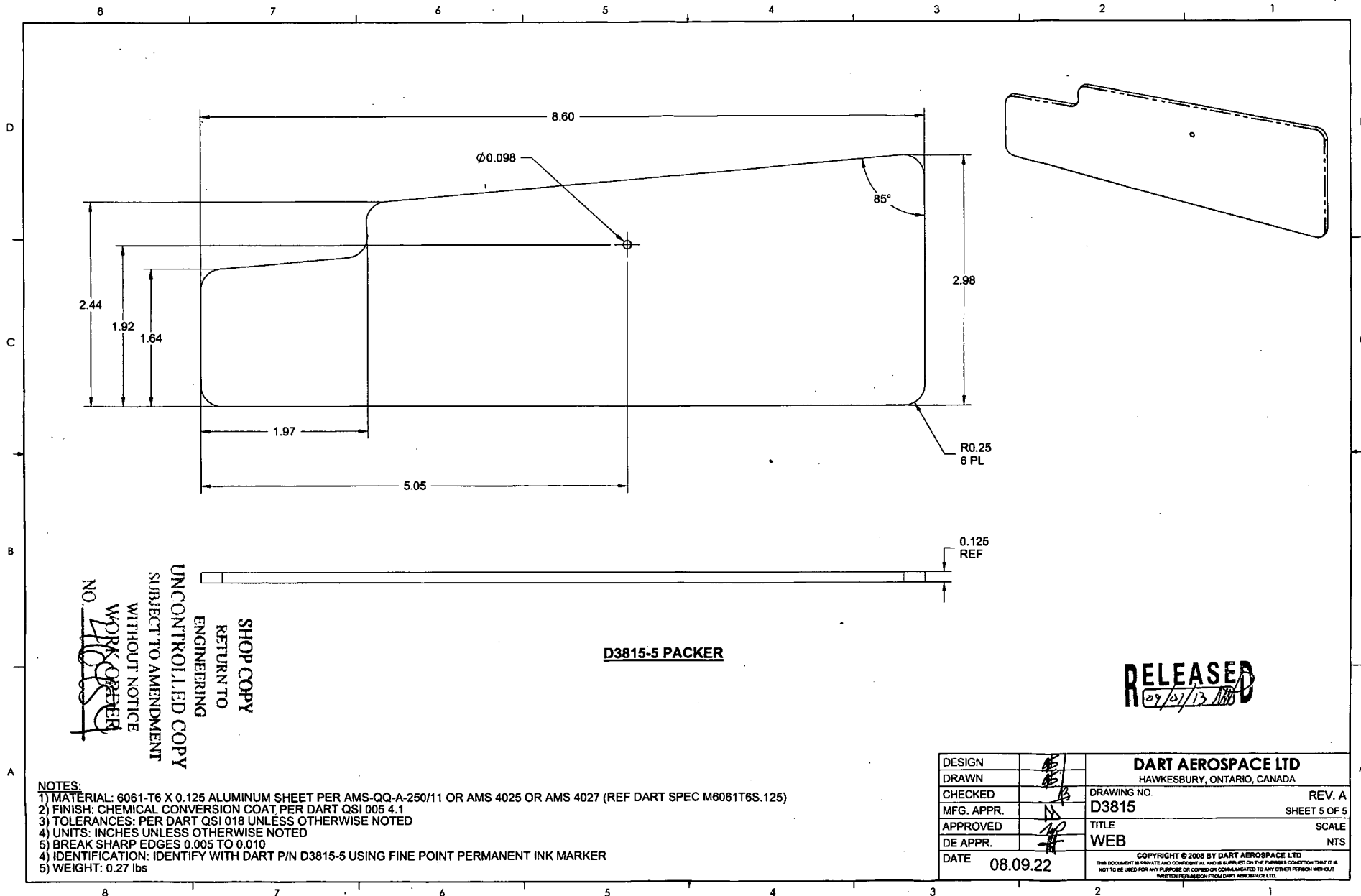
Technical drawing of a 90-degree elbow. The drawing shows a horizontal section with a length of 2.94 and a vertical section with a height of 1.50. The corner is rounded with a radius of R0.25. A 90-degree angle is indicated at the corner.



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D3815-5 PACKER

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NOTES:

- 1) MATERIAL: 6061-T6 X 0.125 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-5 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.27 lbs

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MFG. APPR.		D3815	SHEET 5 OF 5
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DE APPR.		WEB	NTS
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